

Work Order ID 69056



Page 1

Wednesday, April 27, 2011 11:29:16 AM

Item ID: D3443-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Tubing

Start Date: 4/27/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 4-04-27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3443	Rev C								

100		0.00							
	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	1- Form as per Dwg D3443 using DT8117□2- Deburr per dwg D3443								

SB 11/05/02

110		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	GRIND RAD PER DWG								

⇒ M-L 11/05/03

120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

8/11/05/03

(4)

(4X)

(+4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Mill Conv Conventional Milling Machine	CONVENTIONAL MILLING MACHINE Memo 1- Mill end to lenght and drill hole as per dwg D3443 2-Deburr as per dwg D3443	0.00 0.00				<u>4</u>			
140 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				<u>4</u>			
150 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							

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Page 3

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Required Date: 5/3/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
Packaging	Memo	0.00							
Packaging									
170 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/5/17

11/5/18

ME 11-05-17

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, April 27, 2011 11:29:23 AM

Page 1

Work Order ID: 69056

Parent Item: D3443-7

Parent Item Name: Tubing



Start Date: 4/27/2011

Required Date: 5/3/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: A ☐ 05.11.14 ☐ New issue ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TR0.750W.120

Purchased

No

100

f

36.0000

0.75

3.157895



304 ss round tube .750 x .120w



mk 11/04/28

Location

Loc Qty

Loc Code

MAT017

36

114706 ✓

36

3-157895

W/O:		WORK ORDER CHANGES					
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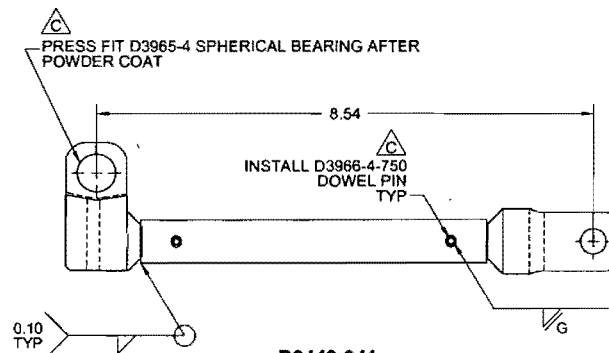
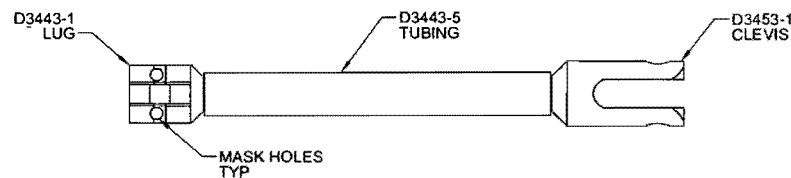
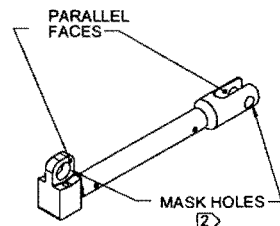
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL



D3443-041


NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.33 lbs
- 8) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69054

11-04-27

RELEASED
09/06/25 MP

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN AB-1, AB-2); 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.551 WAS 0.451 (ZN C1-3); R0.219 WAS R0.050 (ZN C4-3); D3965-4 WAS SPAENLUR PIN (ZN C6-1, B5-2); D3966-4-750 WAS MCMASTER-CARR PIN (ZN B5-1); REF PAR 09-018	RF	09.06.25
B	ADDED .9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø.0.125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO. D3443	
CHECKED		REV. C SHEET 1 OF 4	
MFG. APPR.		TITLE STRUT WELDMENT ASSEMBLY	
APPROVED		SCALE	
DE APPR.		NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

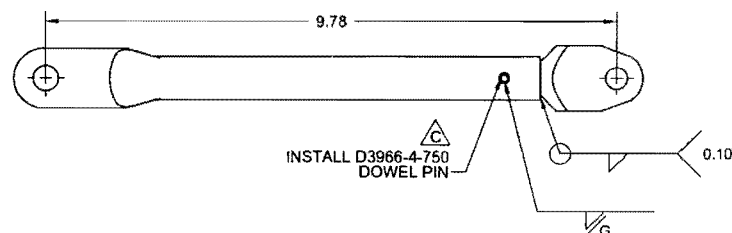
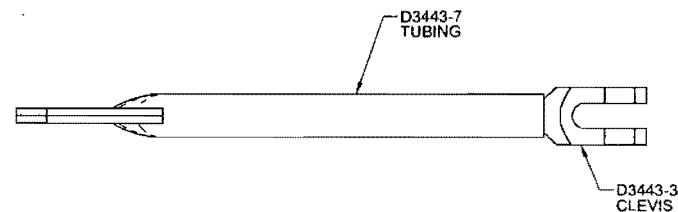
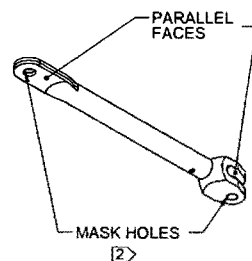
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ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN



D3443-043

w/0 69054

RELEASED
09/06/25

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	UP	DRAWING NO. D3443	REV. C
MFG. APPR.			SHEET 2 OF 4
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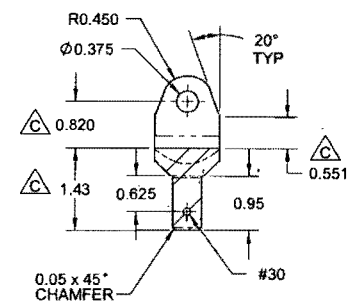
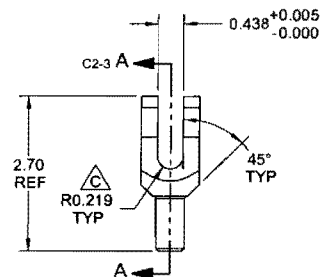
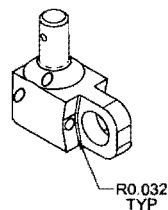
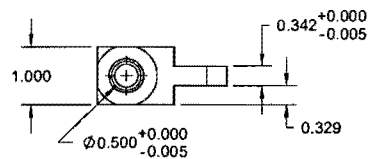
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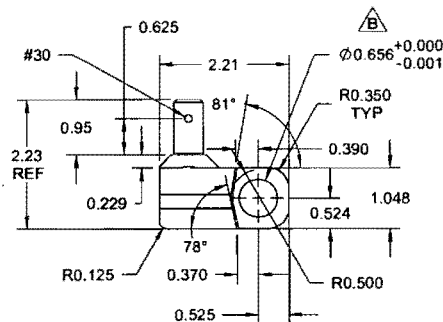
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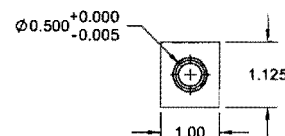
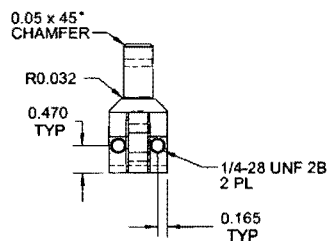
NOTE: Date & initial all entries



SECTION A-A C4-3



D3443-1 LUG



D3443-3 CLEVIS

NOTES:

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 3 OF 4
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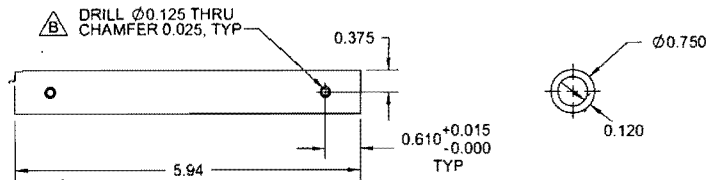
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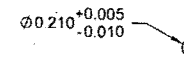
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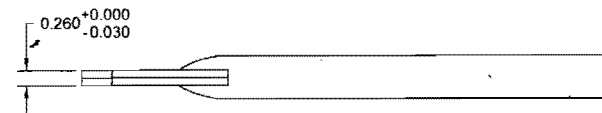


D3443-5 TUBING

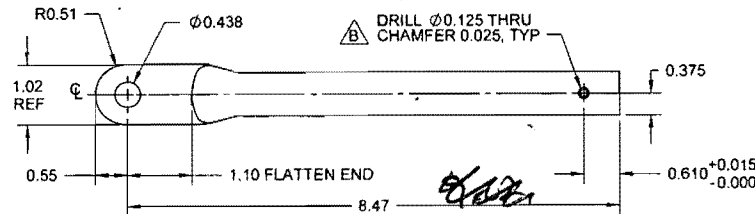


D3443-9 PIN




- D3443-9 NOTES:**
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A



D3443-7 TUBING



- D3443-5/7 NOTES:**
- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: D3443-5 = 0.41 lbs
D3443-7 = 0.62 lbs

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w/o 69054

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